



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.9014

Job Sheet 198146



Part No: 647.9014

Job Qty: 40 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/23/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 SHEET 4 IPP REV: A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Lead Time	
110	Waterjet - Flow - 1	40 pcs		8/23/19	0.00	2.00	Waterjet - Flow	02/19/08/25
120	QC 2	40 pcs		8/23/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	02/19/08/25
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

Plex 7/23/19 8:29 AM Dart.lajeunesse.marie

130 QC 8	40 pcs	8/23/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS 61 9-89
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	40 pcs	8/23/19	0.00 2.00	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	AUG 29 2019
150 QC 5	40 pcs	8/23/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS 40 9-89
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Spray Paint - 2 - B4B	40 pcs	8/23/19	0.00 0.67	Spray Paint - 1 - B4B	AUG 19-8-30
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 14	40	8/23/19	0.00 0.00	QC 14 - 15	

pcs				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	SEP 04 2019 40 8-80
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
210	Packaging 3-1 - Stock - B4B	40 pcs	8/23/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
220	QC21-SA	40 Ea	8/23/19	0.00 0.00	QC 21 - SA - 21
Part Op 110 - 1-Cut as per Dwg Dwg Rev: <u>AI</u> Prog Rev: <u>AI</u> 2-Deburr if necessary Descriptions: 120 - QC 2 130 - QC 8 140 - Form as per drawing. 150 - QC 5 190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) PRIMER BATCH: <u>5195271</u> 200 - QC 14 210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***					

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	1.3200 sf (.033 ea)	110-Waterjet - Flow - 1	S150061	

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	M304S16GA	1	88	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.188Inches	+ 0.005 - 0.001	0.193 0.187	Diameter
2	Strut Bracket	0.195Inches	+ 0.005 - 0.001	0.200 0.194	Diameter
3	Strut Bracket	0.250Inches	+ 0.005 - 0.001	0.255 0.249	Diameter
4	Strut Bracket	1.510Inches	± 0.005	1.515 1.505	
5	Strut Bracket	1.130Inches	± 0.005	1.135 1.125	
6	Strut Bracket	0.393Inches	± 0.005	0.398 0.388	
7	Strut Bracket	0.250Inches	± 0.005	0.255 0.245	
8	Strut Bracket	0.805Inches	± 0.005	0.810 0.800	
9	Strut Bracket	0.063Inches	± 0.005	0.068 0.058	

Plex 7/23/19 8:29 AM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread															
Completed By Lead hand / Supervisor QC / QA Coordinator															